

Work Order ID 83638

April-20-12 2:31:30 PM

ASAP

83638

Page 1

Item ID: D3535-35

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 20/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/23

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3535

Rev B

(17)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

B12-4-26

304 .040

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

S. K. K. K.

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83638

April-20-12 2:31:30 PM

83638

Page 2

Item ID: D3535-35

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 20/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

1-Deburr if necessary2-Form on Brake as per Dwg D3535 using Jigs
DT8261and DT8326.3-Identify as D3535-35.

(17)

0

SB
12/04/27

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/26/27

(47)

0

150

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

3:30

3200F

4:00

17X

MZ
12/24/30

W117338

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Work Order ID 83638

83638

Page 3

April-20-12 2:31:30 PM

Item ID: D3535-35

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 20/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

17 ~~✓~~ 12-24-30

170

Identify as per dwg & Stock Location: FP1

0.00

170

Packaging

Memo

0.00

Packaging

17 ~~✓~~ MK 12-04-30

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/11 ~~✓~~ MK 12-05-01

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NOTE: Date & initial all entries

Picklist Print

April-20-12 2:31:33 PM

Page 1

Work Order ID: 83638

83638

Parent Item: D3535-35

D3535-35

Parent Item Name: Wearshoe

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA		Purchased	No			100	sf	342.3609	0.8022	13.51074	14,		
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M304S20GA

304/316 .040 Sheet

**

B 12-4-26

Location

Loc Qty

Loc Code

001	52.6444105	
121192	52.6444105	
MAT020	289.7165	
117933	27.3442	
118400	6.3723	
118964	30.2	
119346	29.8	
121380	196	

121380

(17)

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DART AEROSPACE LTD		Work Order:	03638
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.004	✓		V IBZ	
1.885	+/-0.010	1.892	✓		V	
6.00	+/-0.030	6.00	✓		✓	
6.75	+/-0.030	6.75	✓		T IBZ	
Ø0.188	+0.005/-0.001	.192	✓		V	
23.250	+/-0.010	23.250	✓		T	
19.750	+/-0.010	19.750	✓		T	
17.750	+/-0.010	17.750	✓		T	
14.250	+/-0.010	14.250	✓		T	
9.500	+/-0.010	9.500	✓		T	
4.750	+/-0.010	4.750	✓		T	
0.300	+/-0.010	.302	✓		V	
0.300	+/-0.010	.301	✓		V	
0.038	+/-0.010	.038	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 12-4-26	Date: 12/4/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

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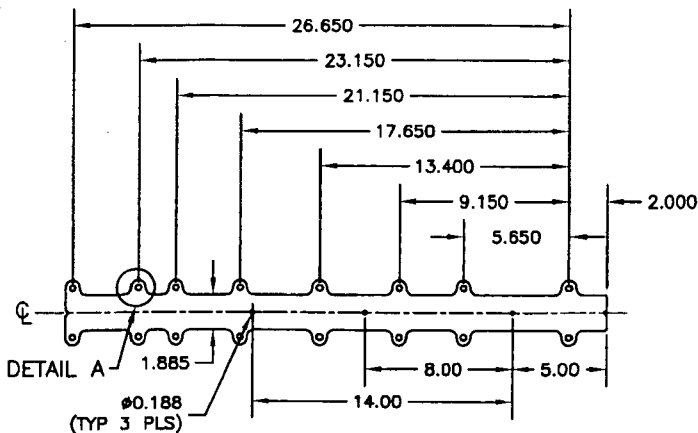
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07.04.17

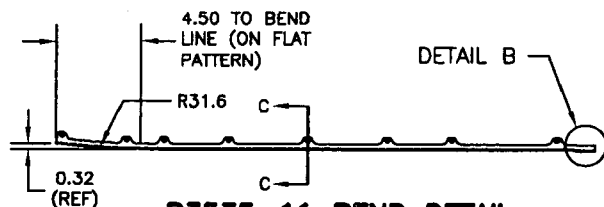
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WORK ORDER

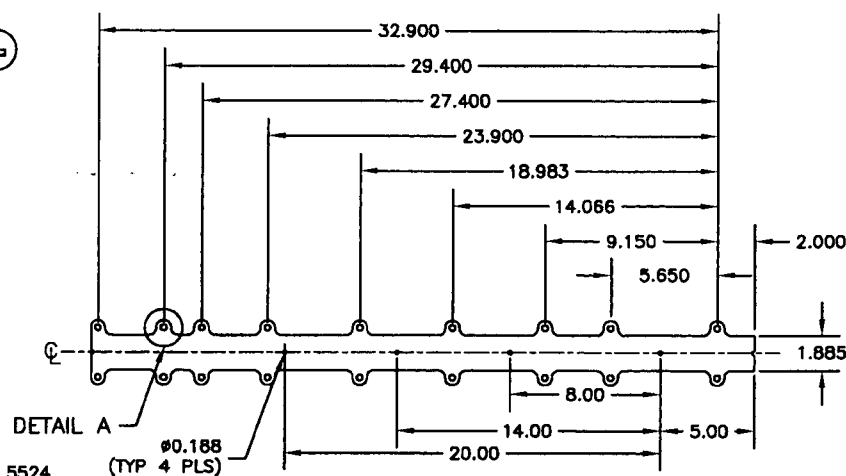
83638 MLC
12/04/23



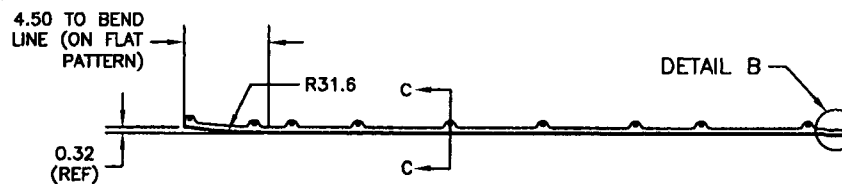
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDETX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	
A	NEW ISSUE	SCALE
		1:10
B	MOVE TAB OUTBOARD, ADD AMS SPEC	

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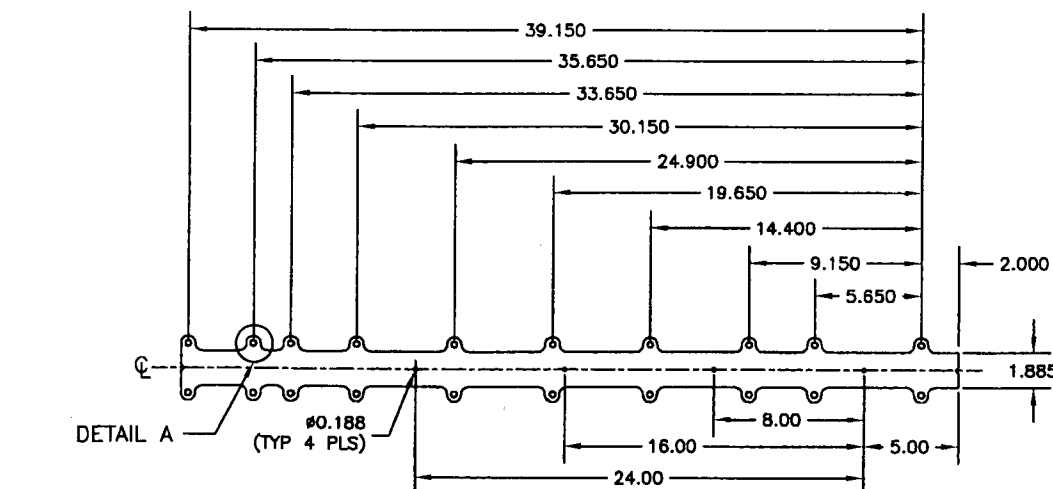
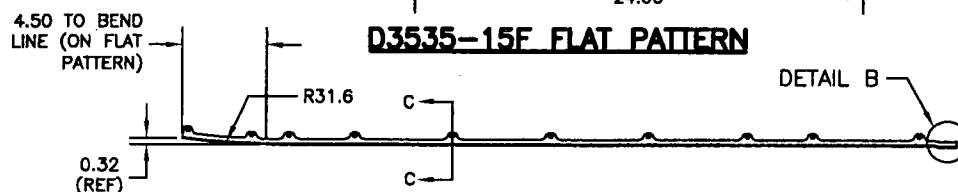
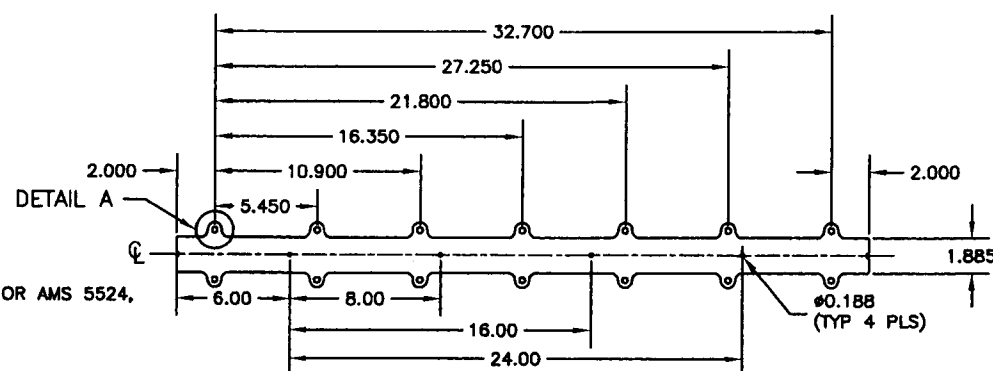
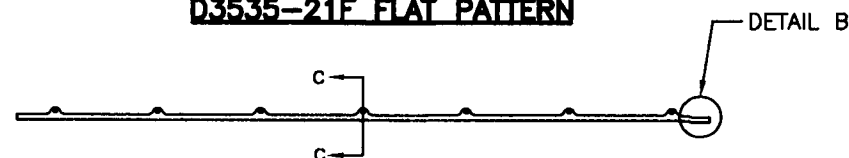
NOTE: Date & initial all entries

03630

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07.04.24

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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		D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
		SHEET 2 OF 7
		REV. B

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

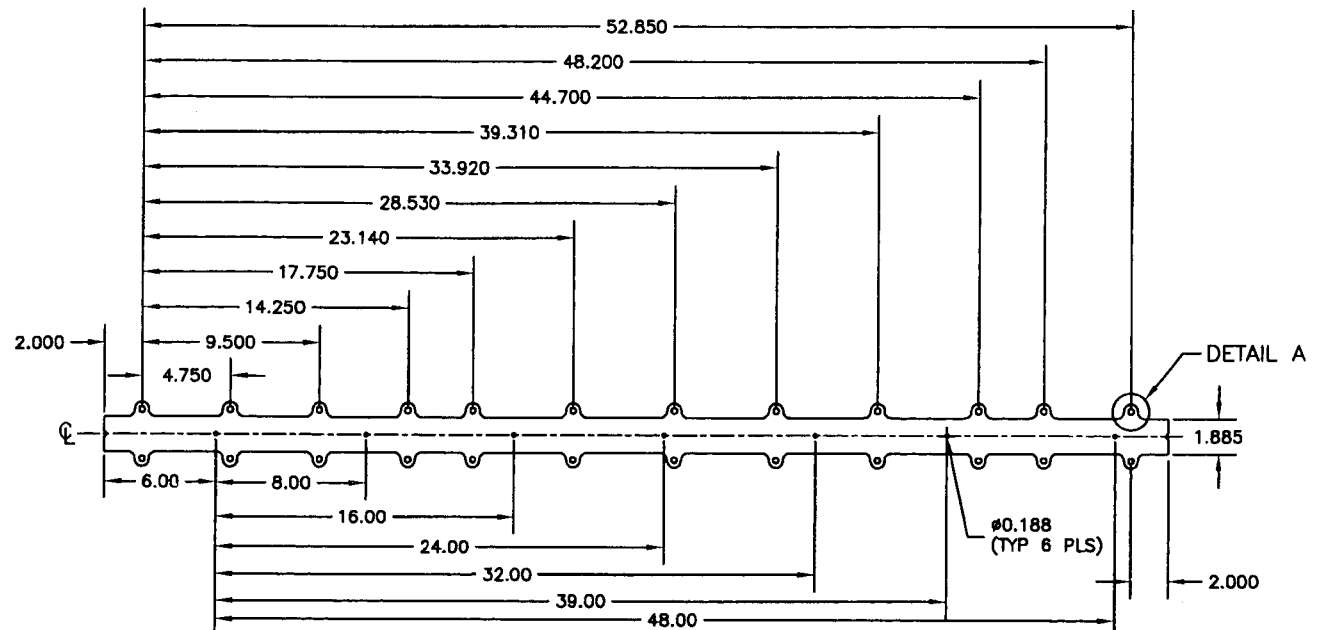
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23632

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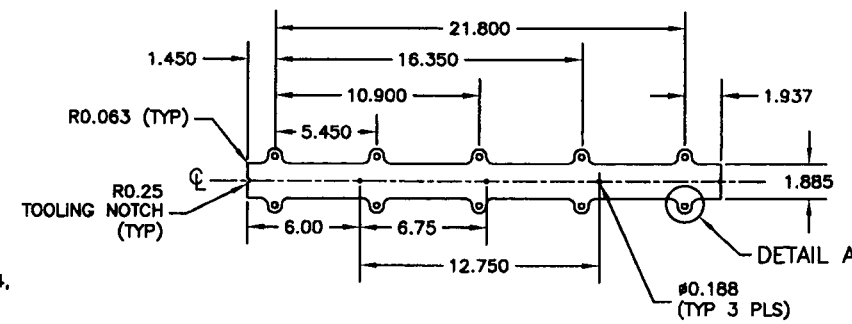
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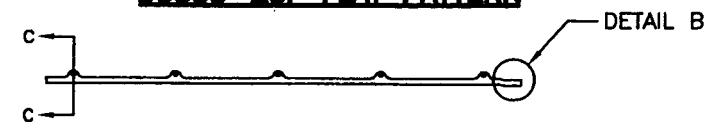
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

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DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 3 OF 7
				SCALE 1:10

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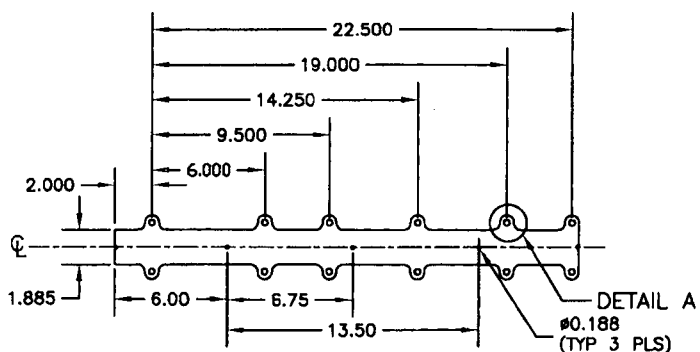
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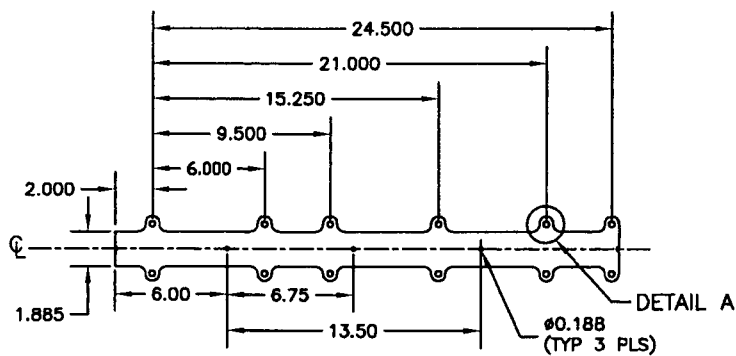
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 4 OF 7	
		SCALE 1:10	

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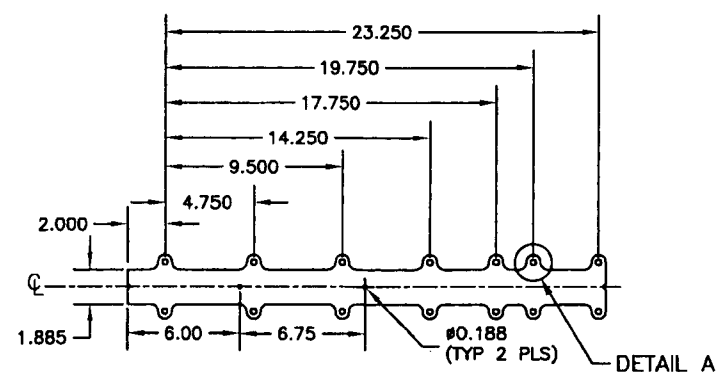
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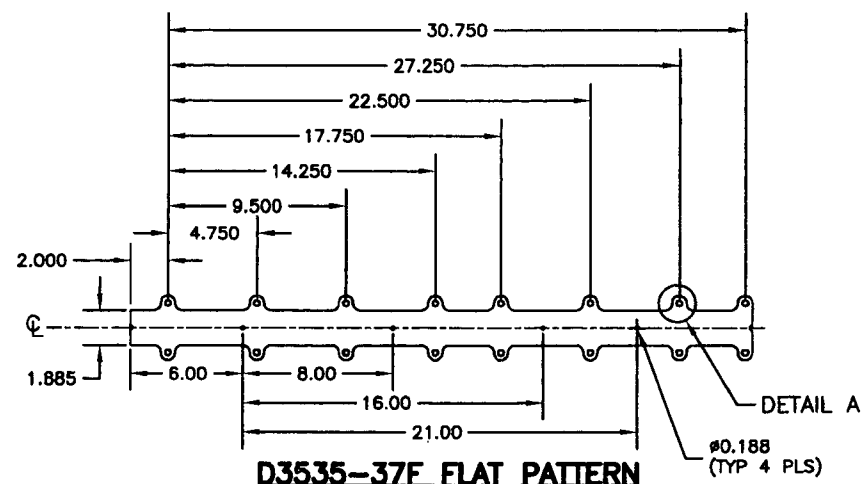
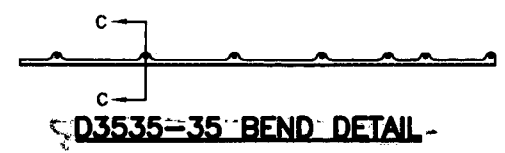
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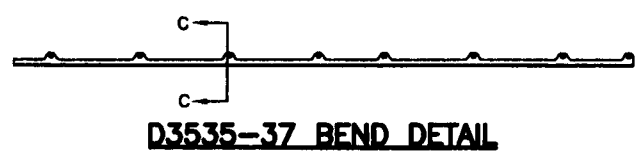
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-37F FLAT PATTERN



NOTES

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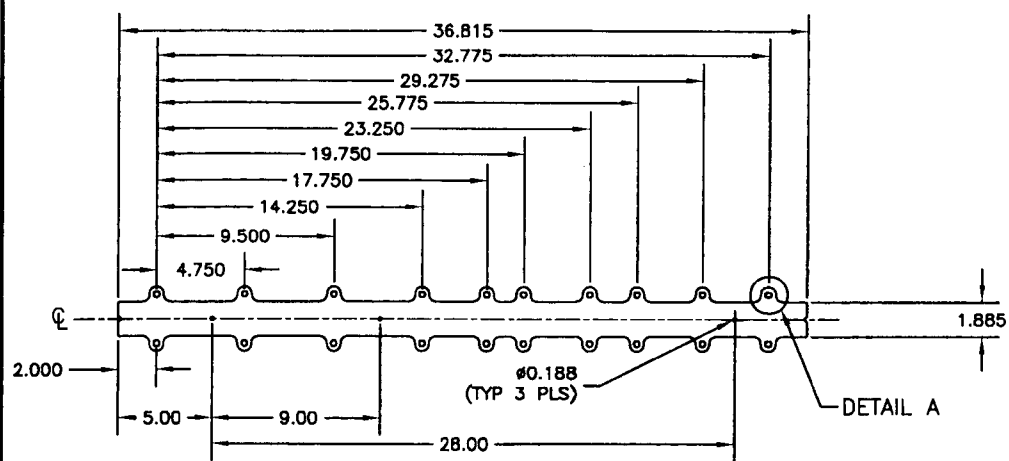
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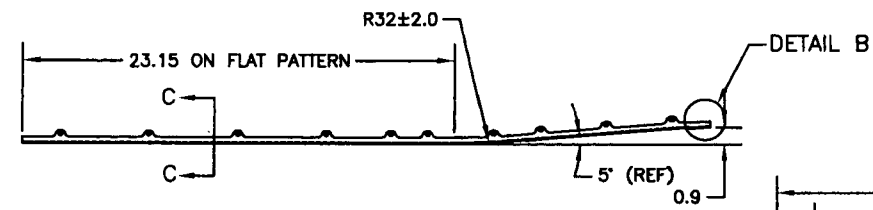
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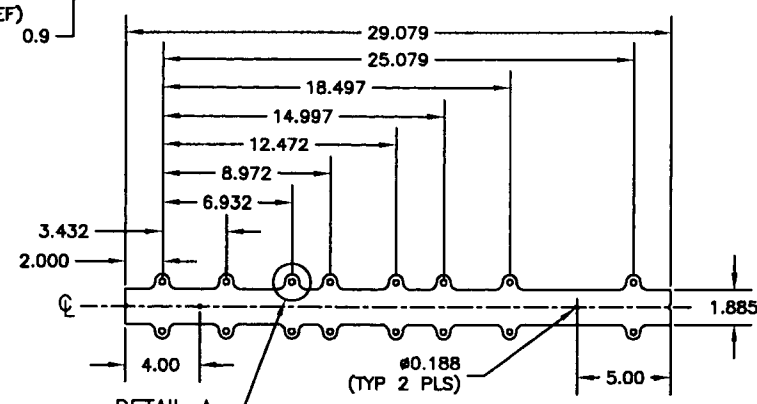
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07.04.17



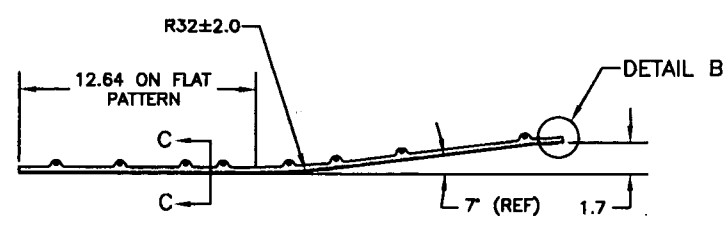
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT CL
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	C B	DRAWN BY	RH	DART AEROSPACE USA, INC.
CHECKED	[Signature]	APPROVED	[Signature]	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	6 OF 7	SCALE
				1:10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

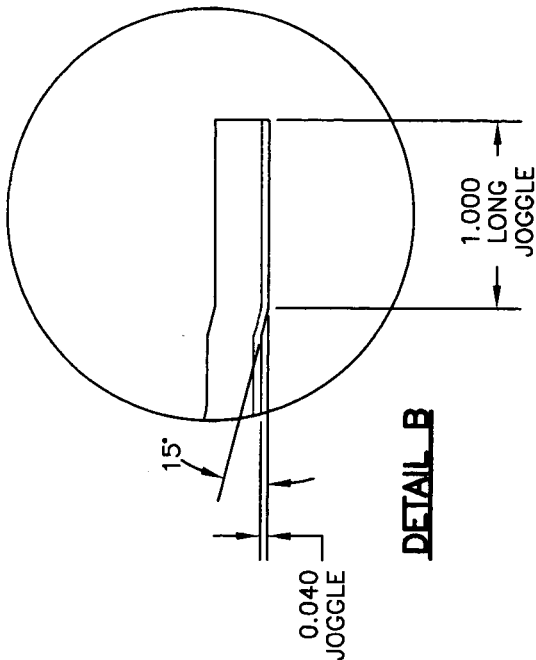
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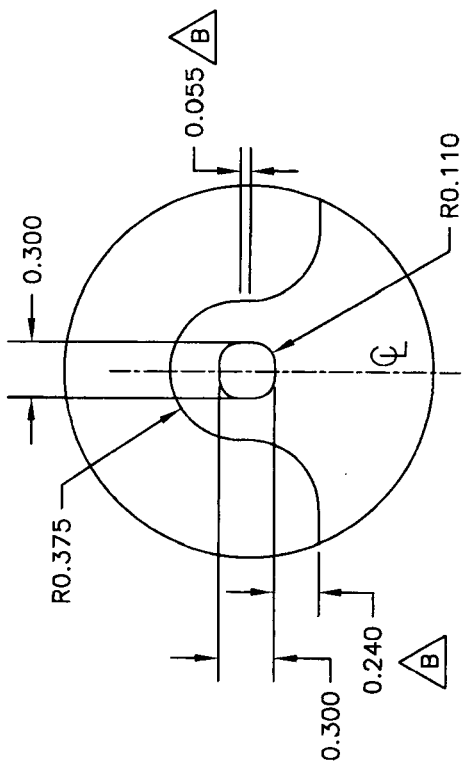
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

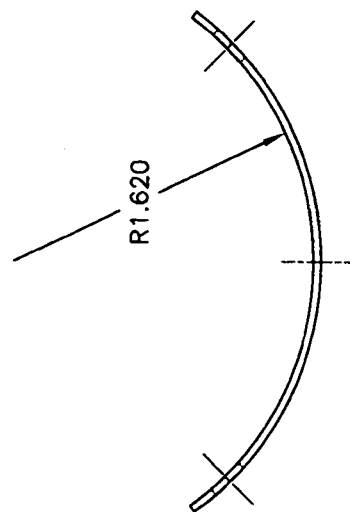
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries